

Work Order ID 76390

November-11-11 12:42:52 PM

~~U/R~~ *76390*

Page 1

Item ID: D3391-023

Accept

N900040100

Setup Start *NSC1*

Stop *NS2*

Revision ID:

Item: Name: Mid Tube Assembly

Start Date: 11/11/2011 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 25/11/2011 **Req'd Qty:** 1.00

Customer:

Reference:

Approvals: Process Plan: M.C.J

Date: _____

Run Start *NP1*

Stop Impact

**Sequence ID/
Work Center ID**

Operation Description

Set Up/ Run Hours

Tool I

Tool # PI
C

Accep
Qty

**Reject
Qty**

reject **Insp.**
umber **Stamp**

Draw Nbr	Revision Nbr	
D3391	Rev H U/R	<i>OK 11.11.14</i>
100		0.00
100	Skidtubes	
Skidtubes	Memo	0.00
Skidtubes		<i>ZS 11-11-16</i>
	1-Cut tube to finish length as per Dwg D3391	
	2-Identify as D3391-023	
	3-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391	
	4-Open saddles and GHW holes to Ø0.375" except for fwd saddle hole of detail "J"	
	5-Remove .030" from Fwd indexing Ridge as per Dwg D3391	
	6-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391	
	7-Deburr	
	8-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,	
	9-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J" do not open wearplate holes of section "J"	
	10-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76390

76390

November-11-11 12:42:52 PM

Page 2

Item ID: D3391-023

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Mid Tube Assembly

Stop

NS2

Start Date: 11/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 25/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:



Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11-Open .375" holes to .438" ***do not open fwd saddle holes***

FT

11 - 11 - 16

12-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)

13- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drilled .188" dia hole, using t-pins and clicos to ensure perfect alignment, open up previously transferred pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021

14- Transfer drill 2 wearplate holes into D3391-021 using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.

15- Locating from two fwd wearplate holes drill remaining 6 wearplate holes in D3391-021 using DT8937

16- Open 2 fwd wearplate holes in D3391-023 to .250" dia.

17- counterbore two aft wearplate holes in D3391-021 as per dwg

18- Open 12 wearplate holes in D3391-021 to 0.297" dia.

19-Deburr and blow out all chips from inside tube

SP

11-11-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Work Order ID 76390

November-11-11 12:42:52 PM

76390

Page 3

Item ID: D3391-023

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NS1

Revision ID:

Item Name: Mid Tube Assembly

Stop

NS2

Start Date: 11/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 25/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

QC5- Inspect part completeness to step on W/O

0.00

WL 11/12/01/00

110

QC

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

DC
11/12/01

120

HandFinish

Hand Finishing

130

QC3- Inspect Part Finish

0.00

DP

11-12-1

130

QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

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Required Date: 25/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

140

Skidtubes

Skidtubes

0.00

1

BB

11-12-01

Memo

0.00

- 1-Open float bag holes as per dwg
 - 2-C'sink float bag holes as per dwg
 - 3- Prepare tube for welding
 - 4-Bond web in place as per Dwg D3391 & QSI 015.
- Adhere for 12 hours)

A/R Sikaflex exp: 11/13/09batch#: 12/08/B

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

1

0

AE 11-12-02

Memo

0.00

160

160

Skidtubes

Skidtubes

0.00

1

0

AE 11-12-02

Memo

0.00

Skidtubes

- 1-Weld crossbolt spacer as per dwg D3391 & QSI 004
- 2-grind weld flush

A/R m118735

1

0

AD 11-12-02

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 76390

November-11-11 12:42:52 PM

76390

Page 5

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NS2

Start Date: 11/11/2011 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 25/11/2011 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

170

QC10- Inspect visual per QSI004- ground welds

0.00

11-12-02

10/12/02

170

QC

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

11-12-02

180

QC

Quality Control

185

Pressure Wash per QSI005 4.3

0.00

10/12/02

185

HandFinish

Hand Finishing

Memo

0.00

AND REALODINE AS PER PAR09-043

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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76390

November-11-11 12:42:52 PM

Page 6

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Start

NS1

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Item Name: Mid Tube Assembly

Stop

NS2

Start Date: 11/11/2011 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 25/11/2011 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

190

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

190

Powdercoat

Powder Coating

W118434

Memo

1-30 0.00
START TIME: 3200°F
OVEN TEMPERATURE:
FINISH TIME: 2-00

XSM/11/12/05

200

QC3- Inspect Part Finish

0.00

200

QC

Quality Control

Memo

0.00

1 11/12/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 76390

76390

Page 7

November-11-11 12:42:52 PM

Item ID: D3391-023

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Mid Tube Assembly

Stop

NS2

Start Date: 11/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 25/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

210

Skidtubes

Skidtubes

0.00

5. ✓ 4/11/2011

Skidtubes

Memo

0.00

1- insert D3391-021 into D3391-23

2- insert T-pins into first and third fwd saddle holes

3- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per DSI 9364

4- remove T-pins and locate DT9415 from first and third crossbolt hole using T-pins and clekos

5- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". Remove DT9415

6- deburr, re-alodine and blow out chips

7- press fit D3591-1 spacers using DT9416 starting from 0.500" side

220

QC5- Inspect part completeness to step on W/O

0.00

S. 4/12/07

220

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 76390

November-11-11 12:42:52 PM

76390

Page 8

Item ID: D3391-023

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Mid Tube Assembly

Stop

NS2

Start Date: 11/11/2011 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 25/11/2011 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals: **Process Plan:** _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

230

230

HandFinish

HandFinishing

0.00

1 4 M 11/12/06

HandFinish

Memo

0.00

Hand Finishing

Install Inserts as per Dwg

240

QC5- Inspect part completeness to step on W/O

0.00

0.00 Sulzlot

1 4 M 11/12/06

240

QC

Quality Control

Memo

250

Identify as per dwg & Stock Location W10

0.00

D412-742-043 / B76398

1 4 M 11/12/06

250

Packaging

Packaging

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 76390

November-11-11 12:42:52 PM

76390

Page 9

Item ID: D3391-023

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Mid Tube Assembly

Stop

NS2

Start Date: 11/11/2011 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 25/11/2011 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

260

QC21- Final Inspection - Work Order Release

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

0.00

0.00

11/12/870

260

QC

Quality Control

Memo

ME
11/12/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-11-11 12:42:58 PM

Page 1

Work Order ID: 76390

76390

Parent Item: D3391-023

D3391-023

Parent Item Name: Mid Tube Assembly

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A05.10.20 New Issue KJ/EC

IPP B06.02.10 ECN773 dwg rev.D EC

IPP C 07.03.20 rev F dwg EC

IPP D 07.03.28 re-format EC

IPP E 07.10.31 ecn 1053P EC

IPP Rev:F ECN 1056 07-11-13 DD verified by: EC

IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC

IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC

IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP

Rev:J add in seq 140 expire date & sikaflex DD 10.02.17 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2500-1-100

Manufactured

No

100

Each

63.0000

1

1

**

D2500-1-100

Skidtube Extrusion

Location	Loc Qty	Loc Code
----------	---------	----------

HALL

63

50251

63

D3391-021

Manufactured

No

100

Each

0.0000

1

1

**

D3391-021

Fwd Tube Assembly

D3389-1

Manufactured

No

75937

140

Each

2.0000

1

**

D3389-1

Web

Location	Loc Qty	Loc Code
----------	---------	----------

LG

76209

2

73433

2

11-11-16

DP 11-11-30

DB 11-12-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

November-11-11 12:42:58 PM

Page 2

Work Order ID: 76390

76390

Parent Item: D3391-023

D3391-023

Parent Item Name: Mid Tube Assembly

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3681-1

Manufactured No

160

Each

49.0000

5

5

**

D3681-1

Spacer

BF-11-12-02
B76004 x 5

Location	Loc Qty	Loc Code
----------	---------	----------

LG	49	
68958	2	
69893	2	
71845	5	
74874	40	

D3591-1

Manufactured No

210

Each

37.0000

2

2

**

D3591-1

Bushing

BL 1112106

Location	Loc Qty	Loc Code
----------	---------	----------

ST068	37	
57350	1	
66147	8	X2
71847	28	

ALS4-1032-130

Purchased No

230

Each

2,000.000

20

20

**

11119530 (x20) BL 1112106

Insert

Location	Loc Qty	Loc Code
----------	---------	----------

ST280	1984	
119084	1984	
ST281	16	
117717	2	
118237	12	
118312	2	

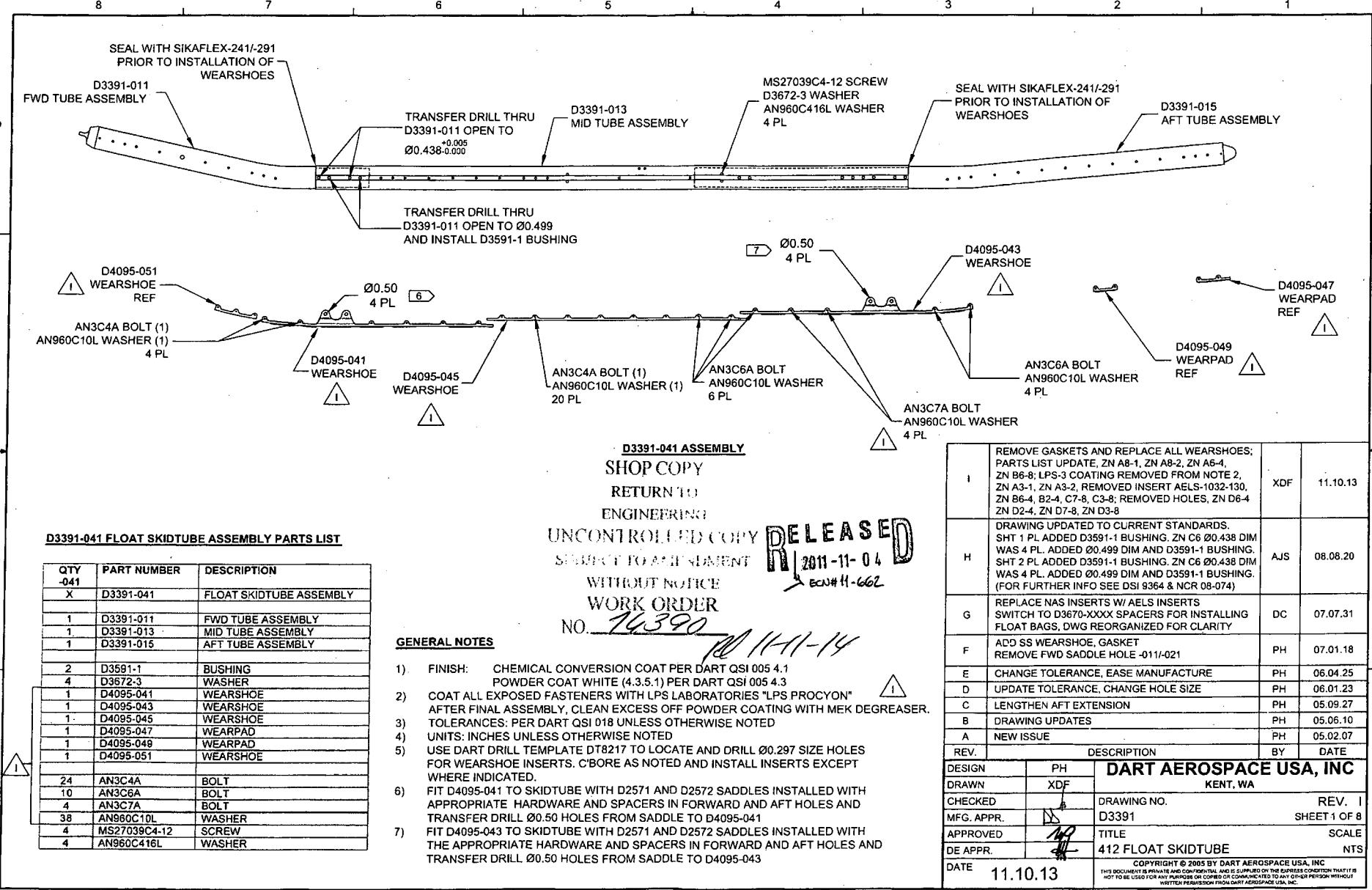
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

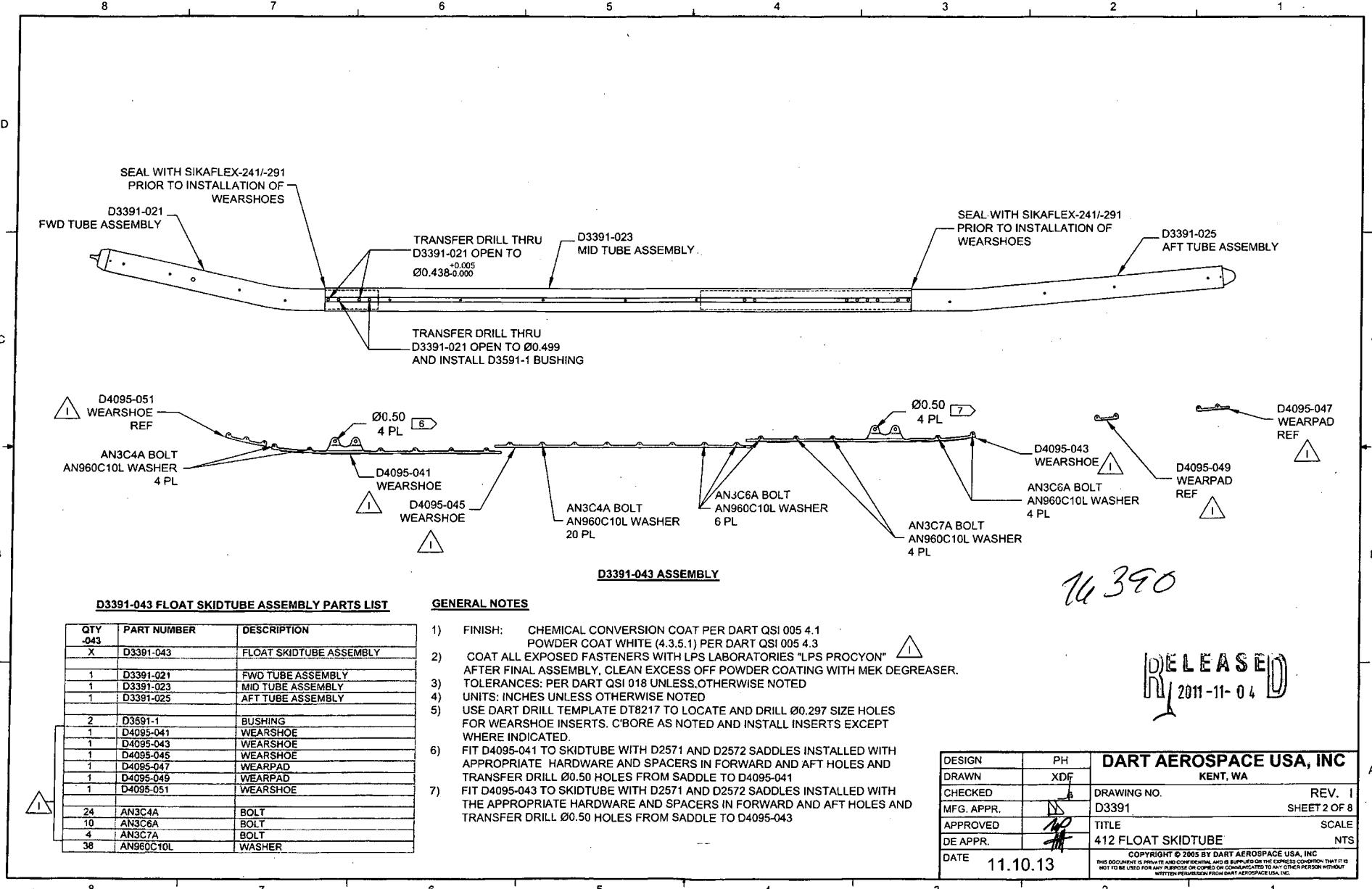
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

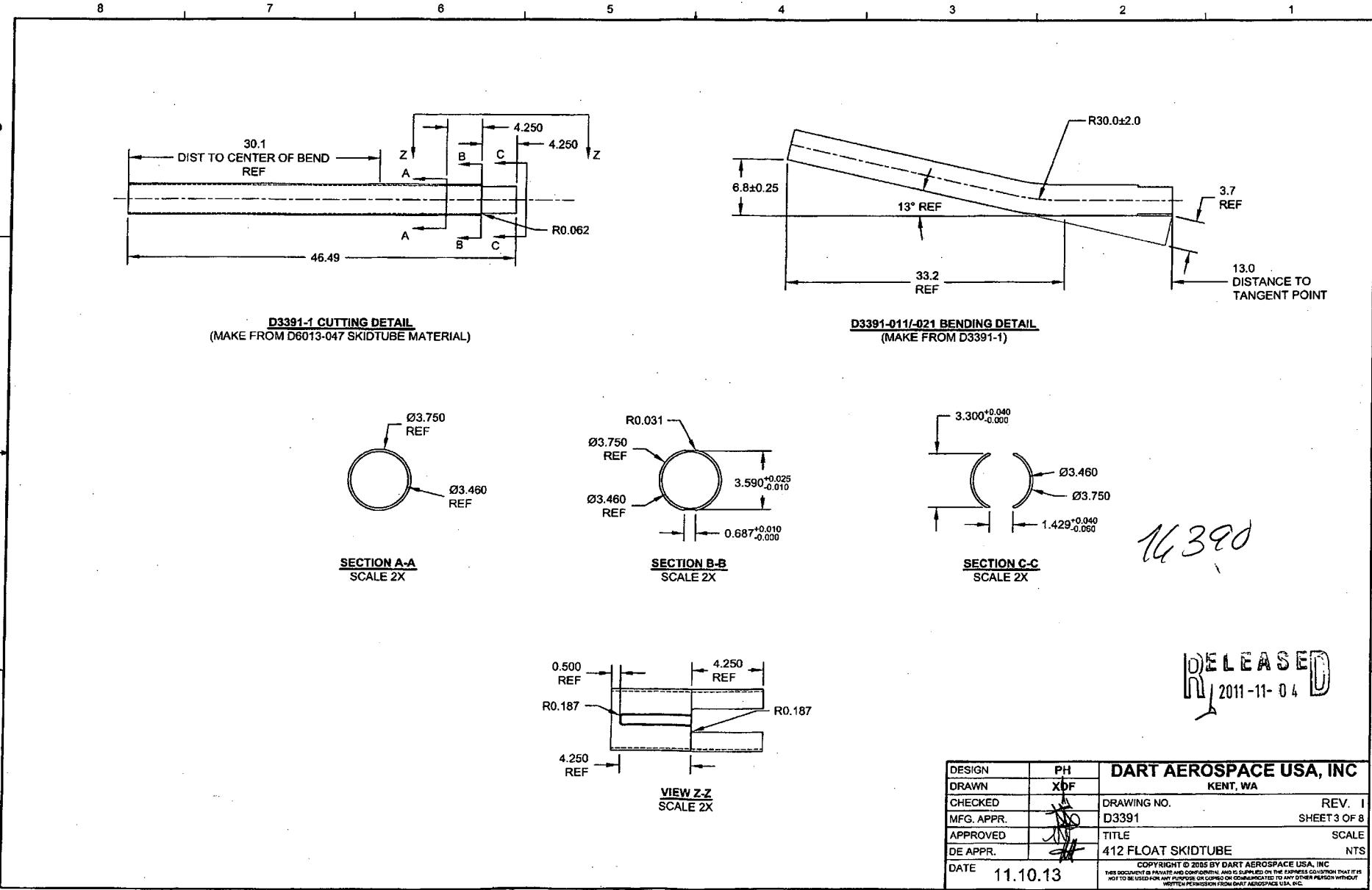


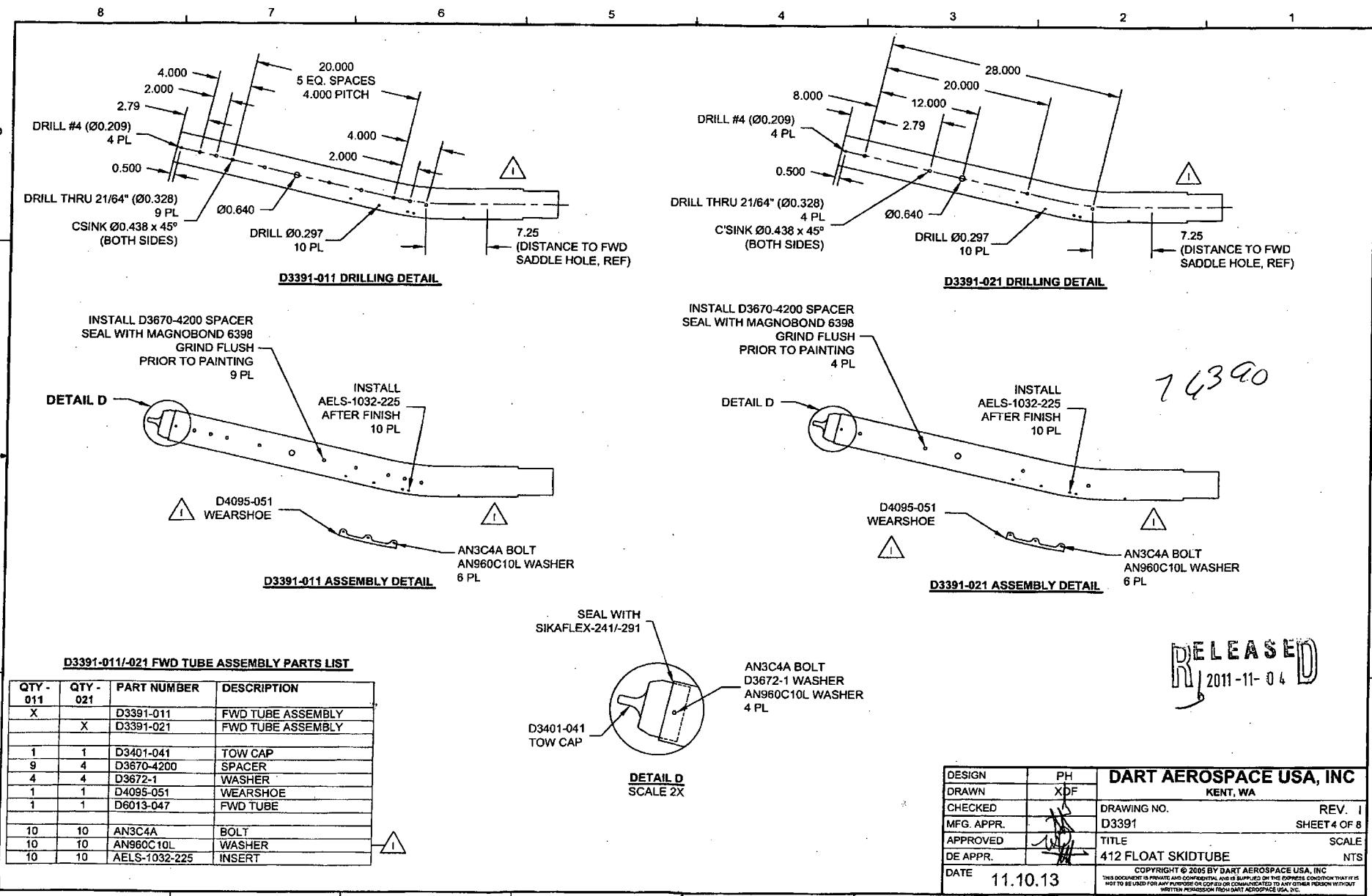


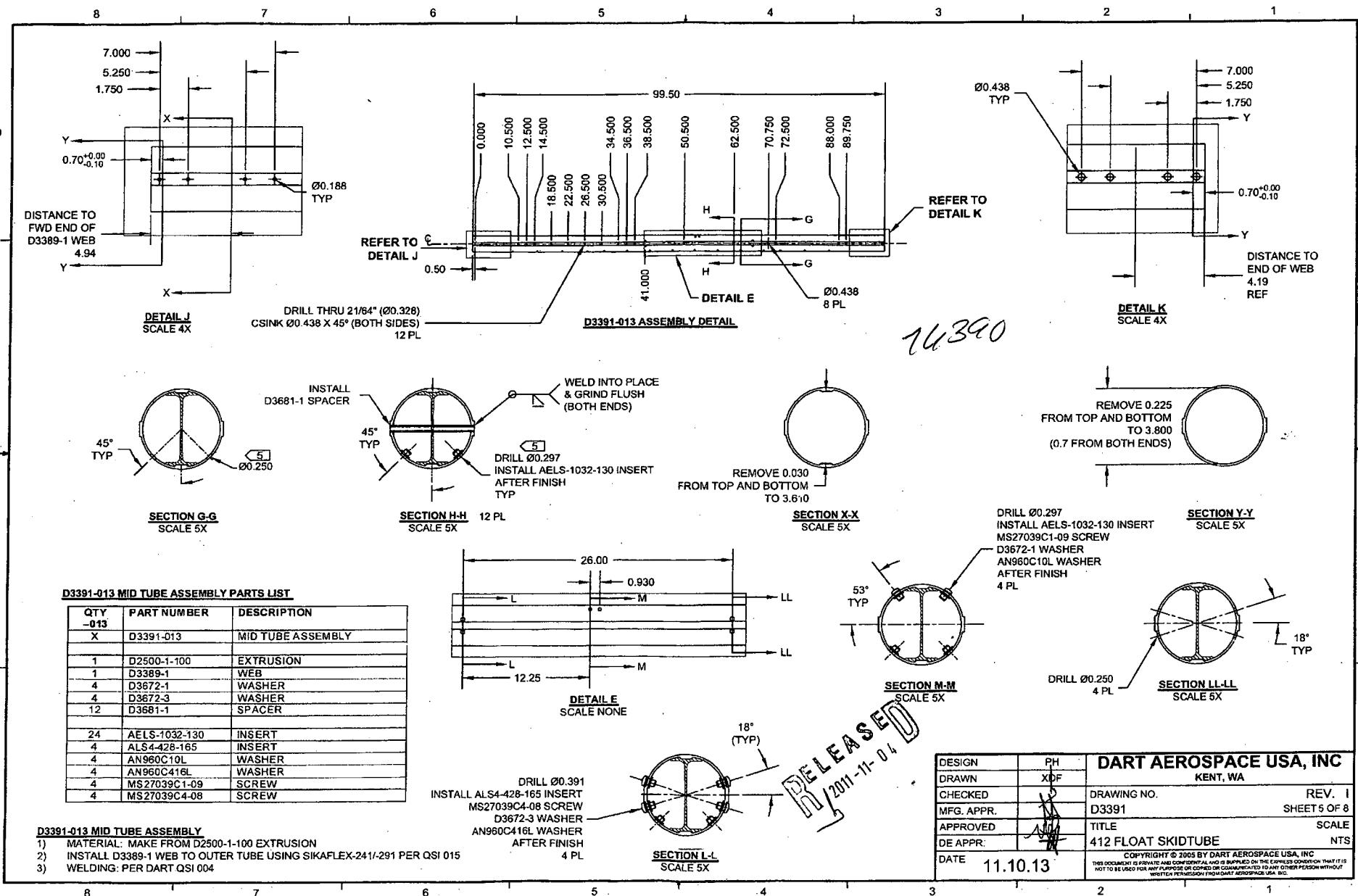
14390

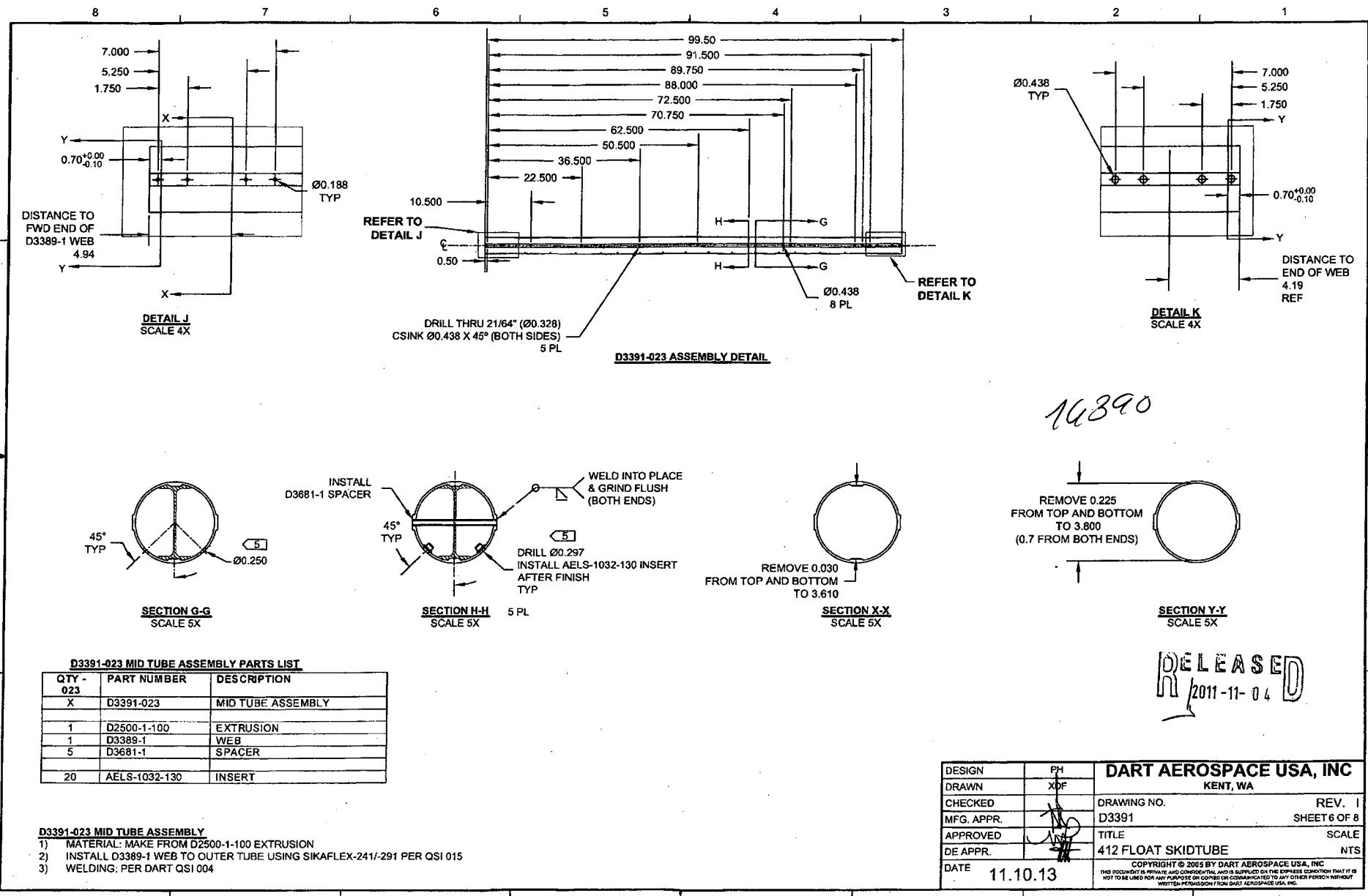
RELEASED
2011-11-04

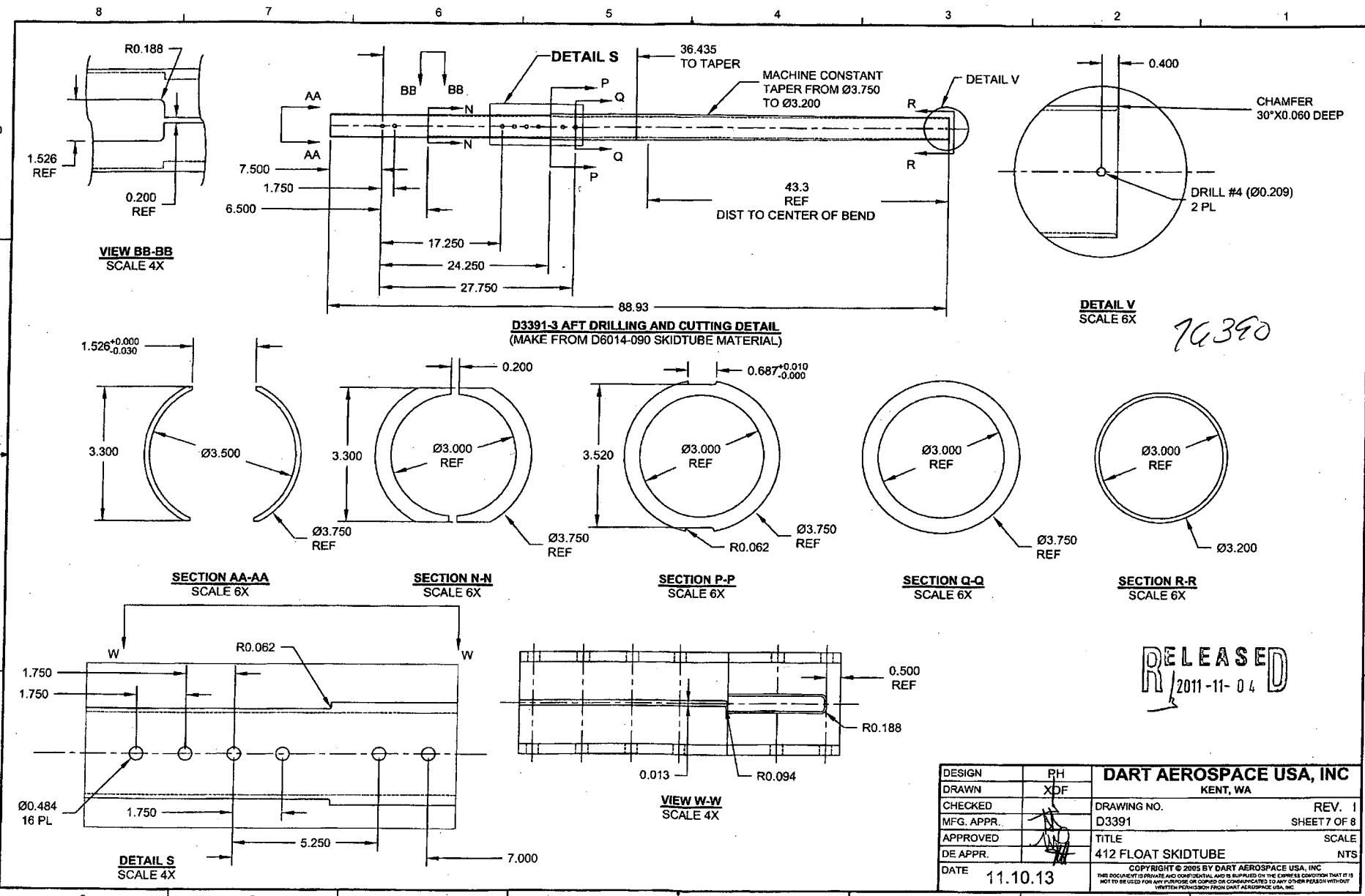
DESIGN	PH	DART AEROSPACE USA, INC		
DRAWN	XDF	KENT, WA		
CHECKED	<i>b</i>	DRAWING NO.	REV. I	
MFG. APPR.	<i>b</i>	D3391	SHEET 2 OF 8	
APPROVED	<i>mg</i>	TITLE	SCALE	
DE APPR.	<i>mg</i>	412 FLOAT SKIDTUBE		NTS
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